

Work Order ID 114521-1

March-10-14 10:58:52 AM

114521

Page 1

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 3/07/14 Start Qty: 10.00

Required Date: 3/14/14 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *MCJ*
QC:

Date: *1403-10*
Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr
D3272

Revision Nbr
Rev B

100 Document Control
100 DOCUMENT CONTROL

0.00

DC Memo
Doc. Control -USB or Paperwork Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

0.00

110
110
Large Fab
Large Fab

Large Fab

Memo
1-Bevel end for welding FWD ONLY

0.00

0.00

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *1103585*

3-Grind End Plate flush

APR 15 2014

MCJ 14-04-15

1103-25 PD

Ac 14-03-10

Ac 14-03-27

SPLIT
(S)

Good

10
10

N900040100

Cust Item ID:
Customer:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14/4/8	110	5	Qty (5) steps have wall thicknesses below tolerance on the side that gets in that has welded lugs	DAS 12 9-89 14/4/8	SCRAP & replace Area around lugs is under high stress and steps have a history of cracking in these areas.			
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--	--

Work Order ID 114521

Friday, March 07, 2014 9:08:15 AM

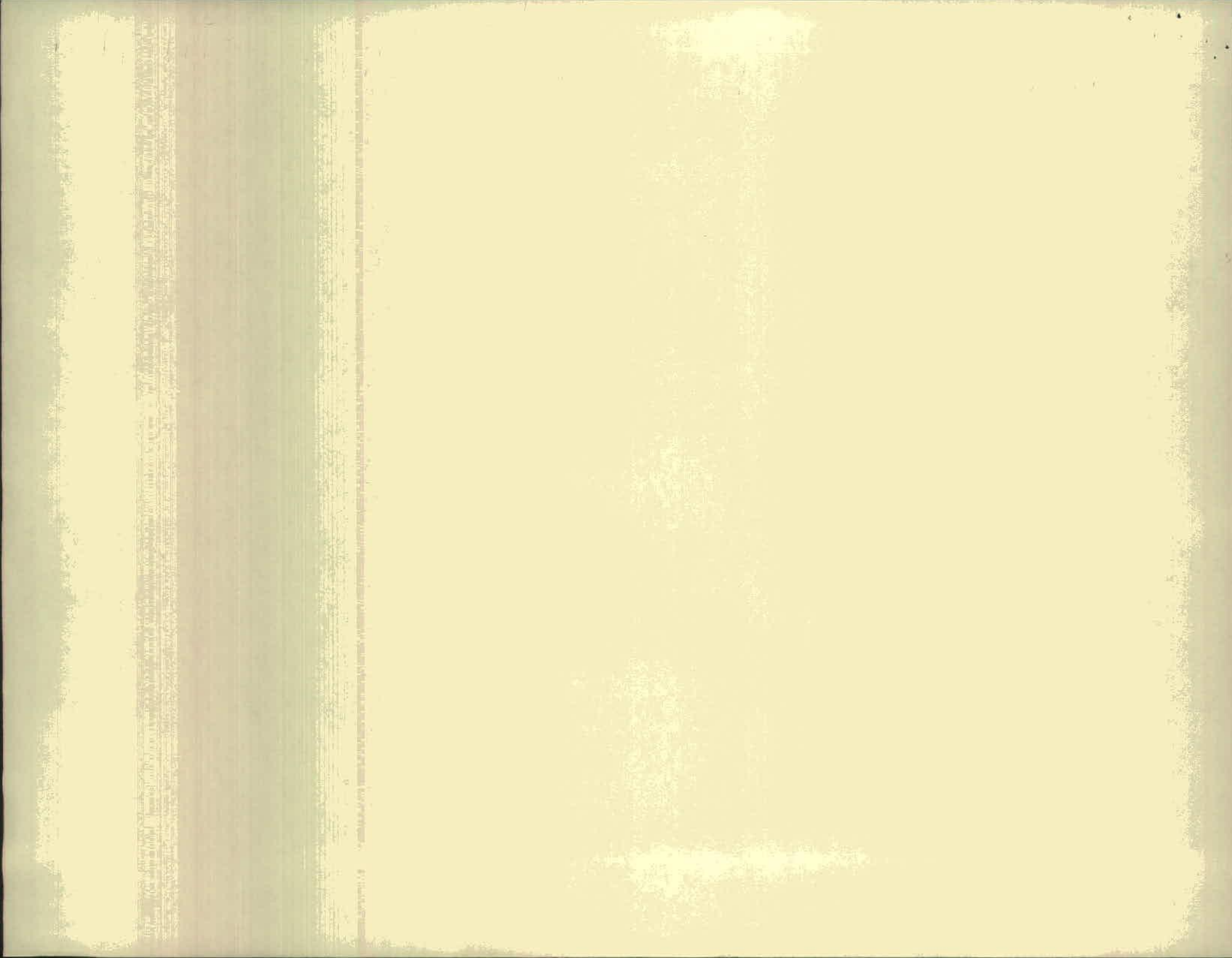
114521

Page 2

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 3/7/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/14/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 14-03-7 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QS1004- Fusion Welds Memo	0.00 0.00				<u>10</u>	<u>0</u>	<u>14-03-31</u>	<i>[Stamp]</i>
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>10</u>			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				<u>10</u>	<u>7/14-4-1</u>		



Work Order ID 114521

Friday, March 07, 2014 9:08:15 AM

114521

Page 3

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ RH
 Start Date: 3/7/2014 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 3/14/2014 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				10	20	14/04/02	
180 *180* Large Fab Large Fab	Large Fab Memo 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod H25091 6-Grind End Plate flush 7-Install last river as per Dwg.	0.00 0.00							

Work Order ID 114521

Friday, March 07, 2014 9:08:15 AM

114521

Page 4

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 3/7/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/14/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 DAS 27 9-89 4/4/11				4 70			
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 4/4/11				4 70			
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	76	144-14	

Work Order ID 114521

Friday, March 07, 2014 9:08:15 AM

114521

Page 5

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ RH
 Start Date: 3/7/2014 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 3/14/2014 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

220

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M128007

0.00

Memo

0.00

START TIME: 1:30

OVEN TEMPERATURE: 320

FINISH TIME: 2:00

H Ø 4-4-14.

DAS 34 9:09

230

230

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M11286003

Memo

0.00

412H of Heli 14/10/14

240

240

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

DAS 27 9:09
14/4/15

4

240
140
100

Work Order ID 114521

Friday, March 07, 2014 9:08:15 AM

114521

Page 6

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 3/7/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/14/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
<p><i>pick one kit only - use 4 kits from B/N 11439B in 4 steps scribbled - kits in pkg.</i></p>									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270									
Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u>H-VI</u>								

(4) *[Signature]* APR 15 2014
 (4) *[Signature]* APR 15 2014
 DAS 06 9:29

Work Order ID 114521

Friday, March 07, 2014 9:08:15 AM

114521

Page 7

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 3/7/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/14/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

ML5 1404-17

1404-17



Friday, March 07, 2014 9:08:35 AM

114521

D350-591-312

Required Date: 3/14/2014

Required Qty: 10.00

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:EC

IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	0.0000	1	10			
D3272-1									**				
Step													
D3067-1		Manufactured	No			110	Each	131.0000	1	10			
D3067-1									**				
End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		131							
				101785		67							
				(102686)		64							
D3219-1		Manufactured	No			110	Each	117.0000	2	20			
D3219-1									**				
Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		117							
				(112125)		117							
D3066-1		Manufactured	No			180	Each	43.0000	2	20			
D3066-1									**				
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		43							
				(106302)		23							
				112583		20							

Picklist Print

Friday, March 07, 2014 9:08:35 AM

Page 2

Work Order ID: 114521

114521

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/7/2014

Required Date: 3/14/2014

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

1,837.000

16

160

MS20600-AD4W4

Rivets

**

(64) 14.04.09

Location

Loc Qty

Loc Code

ST311

~~113075~~
125577

1837

1837

1125577 → 64

D3065-041

Manufactured

No

180

Each

19.0000

1

10

D3065-041

Step Leg Assembly

**

(4) 14.04.09

Location

Loc Qty

Loc Code

WA003

B113075
102830
108770
109447

19

6

10

3

54

D3067-1

Manufactured

No

180

Each

131.0000

1

10

D3067-1

End Plate

**

(4) 14.04.10 PD

Location

Loc Qty

Loc Code

WA003

101785
102686

131

67

64

1015310 → 2

AN3-35A

Purchased

No

250

Each

67.0000

2

20

AN3-35A

Belt

**

Location

Loc Qty

Loc Code

EG

122800

10

10

ST352

m127460
m128300

11

56

N/A see
of 250

✓

Friday, March 07, 2014 9:08:36 AM

Shop Packet Print

Page 2

Picklist Print

Friday, March 07, 2014 9:08:36 AM

Page 3

Work Order ID: 114521

114521

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 3/7/2014

Required Date: 3/14/2014

Start Qty: 10.00

Required Qty: 10.00

D3235-1

Manufactured No

250 Each 199.0000 2 20

D3235-1

Mounting Lug

Location

Loc Qty

Loc Code

ST470

199

102818

13

105939

106

108670

80

D3278-041

Manufactured No

250 Each 54.0000 1 10

D3278-041

Support Assembly

*W/A see of 250 ***

Location

Loc Qty

Loc Code

ST469

50

111885

50

ST470

4

102349

1

109406

3

NAS1149D0463J

Purchased No

250 Each 4,533.000 16 160

NAS1149D0463.I

WASHER

Location

Loc Qty

Loc Code

ST294

450

M127693

450

ST510a

4083

M126221

12

M127813

1071

M127904

3000

Friday, March 07, 2014 9:08:36 AM

Shop Packet Print

Page 3

Picklist Print

Friday, March 07, 2014 9:08:36 AM

Page 4

Work Order ID: 114521

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

114521

D350-591-312

Start Date: 3/7/2014

Required Date: 3/14/2014

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased

No

250

Each

5,229.000

4

40

NAS1149D0563J

Washer

AN5-36A

Purchased

No

AN5-36A

Bolt

Location

Loc Qty

Loc Code

GA

273

m125807

273

ST510a

4956

m126319

2956

m128257

2000

*N/A
see op 250*

250

Each

130.0000

2

20

Location

Loc Qty

Loc Code

ST338

1

M126105

1

st503

129

M127410

29

M127460

100

D2618

Manufactured

No

D2618

Bushing

250

Each

243.0000

2

20

Location

Loc Qty

Loc Code

ST013

243

103863

21

108671

96

97780

126

Friday, March 07, 2014 9:08:36 AM

Shop Packet Print

Page 4

Picklist Print

Friday, March 07, 2014 9:08:36 AM

Page 5

Work Order ID: 114521

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

114521

D350-591-312

Start Date: 3/7/2014

Required Date: 3/14/2014

Start Qty: 10.00

Required Qty: 10.00

D2230-3

D2230-3

Mounting Lug

Manufactured No

250

Each

402.0000

4

40

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST469

395

105940

38

108668

138

109344

218

111818

1

N/A

see 8250

D2856-400

D2856-400

Abrasion Strip 4" Wide (Per Foot)

Manufactured No

250

f

348.1000

1.2

✓ 12

Location

Loc Qty

Loc Code

ST403

348.1

109578

132.1

112524

216

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250

Each

4,530.000

2

20

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST314

3575

M127410

2534

M127831

41

M128401

1000

ST506

955

123900

955

Friday, March 07, 2014 9:08:37 AM

Shop Packet Print

Page 5

Picklist Print

Friday, March 07, 2014 9:08:37 AM

Page 6

Work Order ID: 114521

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

114521

D350-591-312

Start Date: 3/7/2014

Required Date: 3/14/2014

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

AN4-13A

Bolt

Purchased

No

250

Each

1,928.000

8

80

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

14

m125709

14

ST515

1894

m126193

12

m127432

36

m127817

846

m128403

1000

250

Each

874.0000

2

20

MS21042L5

MS21042L 5

Nut

Purchased

No

Location

Loc Qty

Loc Code

GA

5

117611

5

ST315

369

m127304

369

ST509

500

m127813

500

Friday, March 07, 2014 9:08:37 AM

Shop Packet Print

Page 6

Picklist Print

Friday, March 07, 2014 9:08:37 AM

Page 7

Work Order ID: 114521

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

114521

D350-591-312

Start Date: 3/7/2014

Required Date: 3/14/2014

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

5,648.000

8

80

MS21042L 4

Locknut

Location

Loc Qty

Loc Code

ST314

32

m126275

32

ST509

5605

m127255

657

m127813

1948

m128300

3000

ST518

11

m127376

11

NAS1149D0363J

Purchased

No

250

Each

1,729.000

4

40

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

1706

m126319

514

m127813

1192



DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

114521
R14-03-7

Copyright © 2004 by DART AEROSPACE LTD

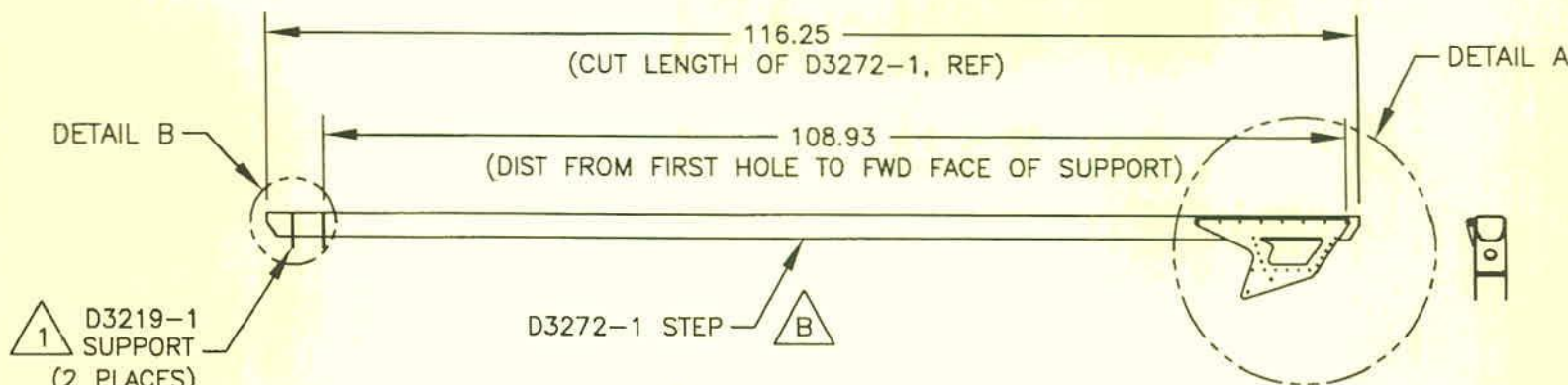
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

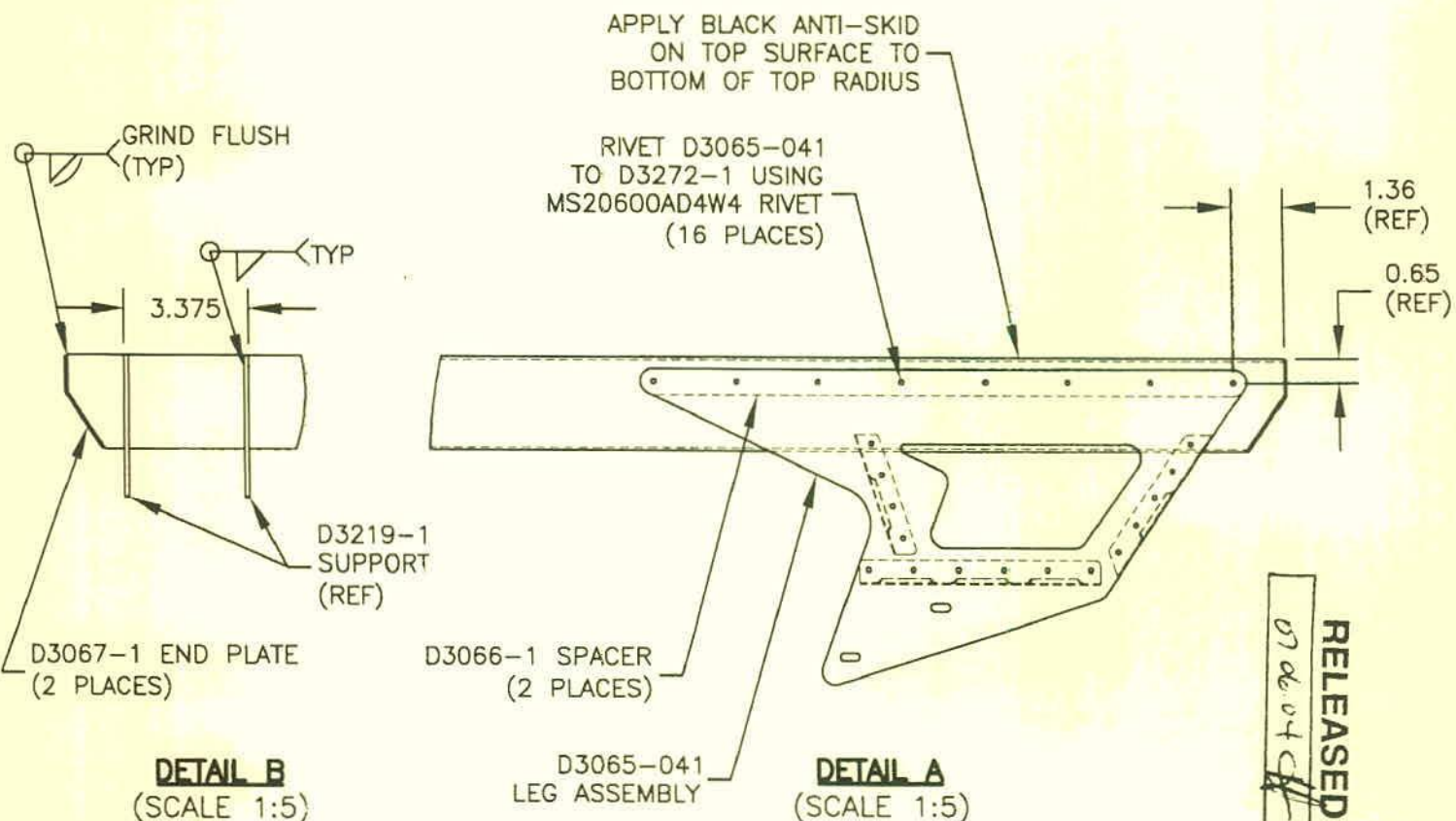
DESIGN	q	DRAWN BY	REV. B
CHECKED	CE	APPROVED	SHEET 2 OF 3
DATE	07.05.18	DRAWING NO.	SCALE
		D3272	1:20
		TITLE	
		STEP ASSEMBLY, HI LONG	

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

RELEASED
07 de oct 18

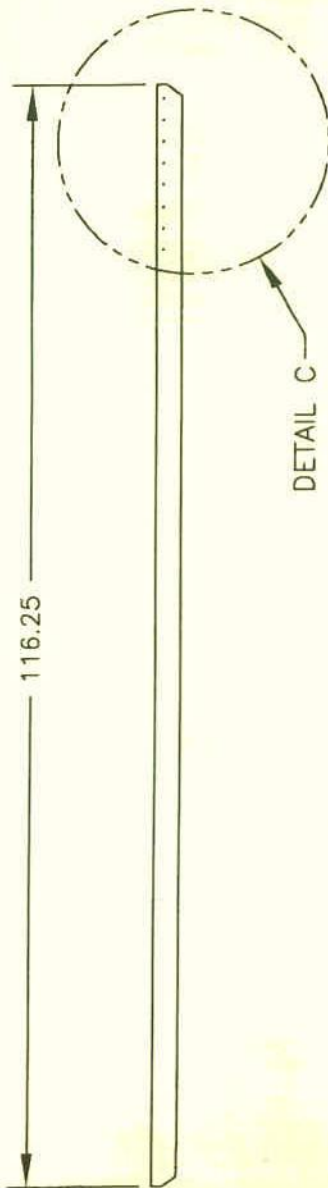


D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DART

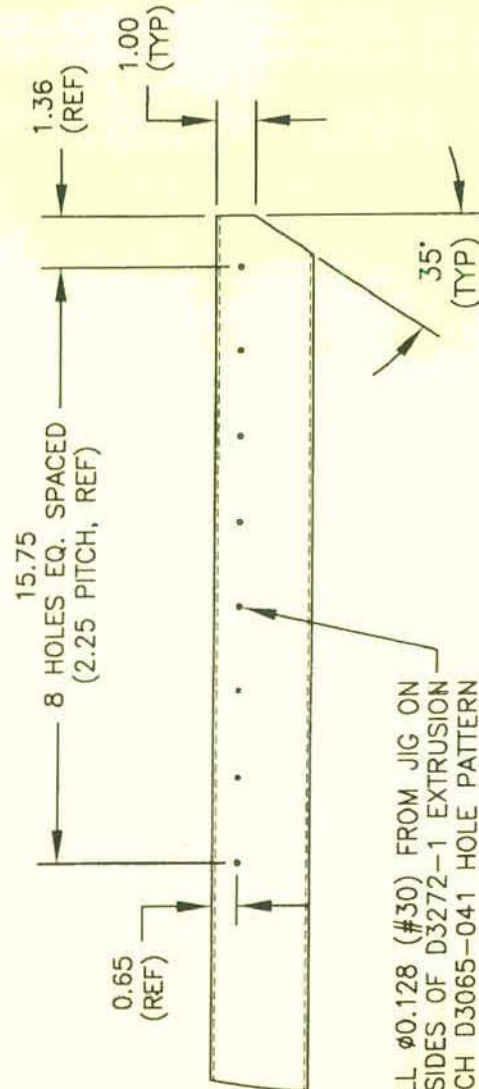
DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED07.06.04 *[Signature]*

DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN**DETAIL C**

(SCALE 1:5)

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

